

Work Order ID 59082

May 26, 2010 9:06:08 AM



Page 1

Item ID: D3913-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Base Assembly, 350

Start Date: 5/26/10 Start Qty: 1.00



Cust Item ID:

Required Date: 6/03/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3913

A

100

Weld per dwg A/R S.S. rod Batch: M113328 0.00



Large Fab

Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D3913 using DT9610A
inspect before welding mesh
2- tack weld mesh on basket as per dwg D3913 and trim mesh to fit
3- weld hinge (3) and Mounting brackets as per dwg D3913
take lid to locate hinge and bracket

Handwritten: 10/06/02 (10)

Handwritten: RPL 10.06.02

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

Handwritten: 10.06.02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




Work Order ID 59082

May 26, 2010 9:06:08 AM

Page 2

Item ID:	D3913-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Long Basket Base Assembly, 350					
Start Date:	5/26/10	Start Qty:	1.00		Cust Item ID:	
Required Date:	6/03/10	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		Sc066603					
130  Powdercoat Powder Coating	*POSSURE WASIK White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel Memo 1- Plug holes and mask only interior of hinge (3) prior to powder coat M114207 1ST COAT: START TIME: 12:00pm OVEN TEMPERATURE: 400°F FINISH TIME: 12:30pm ***** 2nd coat if necessary ***** 2ND COAT: START TIME: 12:45pm OVEN TEMPERATURE: 400°F FINISH TIME: 1:15pm	0.00 0.00		=> M 10/06/03		1			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May 26, 2010 9:06:04 AM

Page 1

Work Order ID: 59082

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Date: 5/26/10

Required Date: 6/03/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2581
Mounting Bracket

Location	Loc Qty	Loc Code
WA	34	
46086	2	
51745	2	
57185	1	
58301	9	
58687	20	

D3913-1		Manufactured	No			100	Each	0.0000	1				
---------	--	--------------	----	--	--	-----	------	--------	---	--	--	--	--

Rib

D3913-15		Manufactured	No			100	Each	10.0000	1				
----------	--	--------------	----	--	--	-----	------	---------	---	--	--	--	--

Wide Handle Plate

Location	Loc Qty	Loc Code
WA	10	
58125	7	
58586	3	

D3913-3		Manufactured	No			100	Each	1.0000	1				
---------	--	--------------	----	--	--	-----	------	--------	---	--	--	--	--

Rib

Location	Loc Qty	Loc Code
WA	1	
58578	1	

D3913-7		Manufactured	No			100	Each	0.0000	2				
---------	--	--------------	----	--	--	-----	------	--------	---	--	--	--	--

Rib

2
SS 10/06/01

②
B58741 ① SS 10/06/01

1
SS 10/06/01

①
B58742 ① 10/06/01

2
B58690 ② SS 10/06/01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

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Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
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IPP Rev:B

Start Date: 5/26/10

Required Date: 6/03/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3913-9		Manufactured	No			100	Each	1.0000	1	1			
												SY 10/06/01	
Hinge Rib													

Location Loc Qty Loc Code

WA

1

58582

1

D3916-041

Manufactured

No

100

Each

0.0000

2



Rib Assembly



①

B 58688 ② SY 10/06/01

D3916-5

Manufactured

No

100

Each

2.0000

3



Light Rib



3

B 58678 ③ SY 10/06/01

Location Loc Qty Loc Code

WA

2

57023

2

D4016-1

Manufactured

No

100

Each

6.0000

3



Hinge Half, Base



3

SY 10/06/01

Location Loc Qty Loc Code

WA

6

58657

6

D4017-7

Manufactured

No

100

Each

3.0000

1



Rib



③

SY 10/06/01

Location Loc Qty Loc Code

WA

3

58133

1

58521

2

①

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Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 3

Work Order ID: 59082

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 5/26/10





Required Date: 6/03/10


Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B


Start Qty: 1.00

Required Qty: 1.00


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status																		
D4017-9 		Manufactured	No			100	Each	0.0000	2	2																					
Rib																															
D4020-1 		Manufactured	No			100	Each	0.0000	1	1																					
Mesh (350 Basket Long, Base)																															
D4020-11 		Manufactured	No			100	Each	4.0000	2	2																					
End Mesh, Basket																															
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>WA</td><td>4</td><td></td></tr><tr><td>56990</td><td>1</td><td></td></tr><tr><td>58136</td><td>3</td><td></td></tr></table>														Location	Loc Qty	Loc Code	WA	4		56990	1		58136	3							
Location	Loc Qty	Loc Code																													
WA	4																														
56990	1																														
58136	3																														
D4021-1 		Manufactured	No			100	Each	16.0000	3	3																					
Handle Plate																															
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>ST109</td><td>5</td><td></td></tr><tr><td>57086</td><td>5</td><td></td></tr><tr><td>WA</td><td>11</td><td></td></tr><tr><td>58525</td><td>2</td><td></td></tr><tr><td>58746</td><td>9</td><td></td></tr></table>														Location	Loc Qty	Loc Code	ST109	5		57086	5		WA	11		58525	2		58746	9	
Location	Loc Qty	Loc Code																													
ST109	5																														
57086	5																														
WA	11																														
58525	2																														
58746	9																														




B58689②



B59025①



B58136②



②③

SY 10/06/01

SY 10/06/02

SY 10/06/02

SY 10/06/01

B58689 ② SJ 10/06/01

B59025 ① SJ 10/06/02

B58136 ② SJ 10/06/02

SJ 10/06/01

② ③

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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May 26, 2010 9:06:06 AM

Work Order ID: 59082

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 5/26/10


Required Date: 6/03/10

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B


Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4034-041		Manufactured	No			100	Each	5.0000	1	1			
													
Aft Upper Rib Assembly													


Location Loc Qty Loc Code

WA 5
58141 2
58696 3

D4034-043		Manufactured	No			100	Each	3.0000	1	1			
													
Fwd Upper Rib Assembly													


Location Loc Qty Loc Code

WA 3
58697 3

AN3-10A		Purchased	No			150	Each	60.0000	6	6			
													
Bolt													

Location Loc Qty Loc Code

ST351 60
114330 60

AN960JD8	NAS1149DN832 J	Purchased	No			150	Each	0.0000	2	2			
													
Washer													

Washer Q57017

NAS1149DN832 J M114740 (25)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 59082

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC





IPP Rev:B

Start Date: 5/26/10

Required Date: 6/03/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2931  Bumper		Manufactured	No			150	Each	858.0000	2	2		5/30/06/03	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST504		858				2			
				46064		858							
D4021-5  Blanking Plate		Manufactured	No			150	Each	9.0000	2	2		5/30/06/03	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST109		9							
				58140		9				2			
MS20600-AD4W3  Cherry Rivets		Purchased	No			150	Each	1,785.000	2	2		5/30/06/03	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST321		1785							
				106375		3							
				107939		822							
				111636		960				2			
MS21042L3  Nut		Purchased	No			150	Each	1,722.000	6	6		5/30/06/03	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST300		1722							
				113537		20							
				113644		202							
				114523		1000				6			
				114718		500							

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 59082



Parent Item: D3913-041



Parent Item Name: Long Basket Base Assembly, 350

Start Date: 5/26/10

Required Date: 6/03/10

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
NAS1149F0332P		Purchased	No			150	Each	811.0000	12	12			



WASHER



5/30/06/03

Location

Loc Qty

Loc Code

ST275

811

18057

811

12

May 26, 2010 9:06:07 AM

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

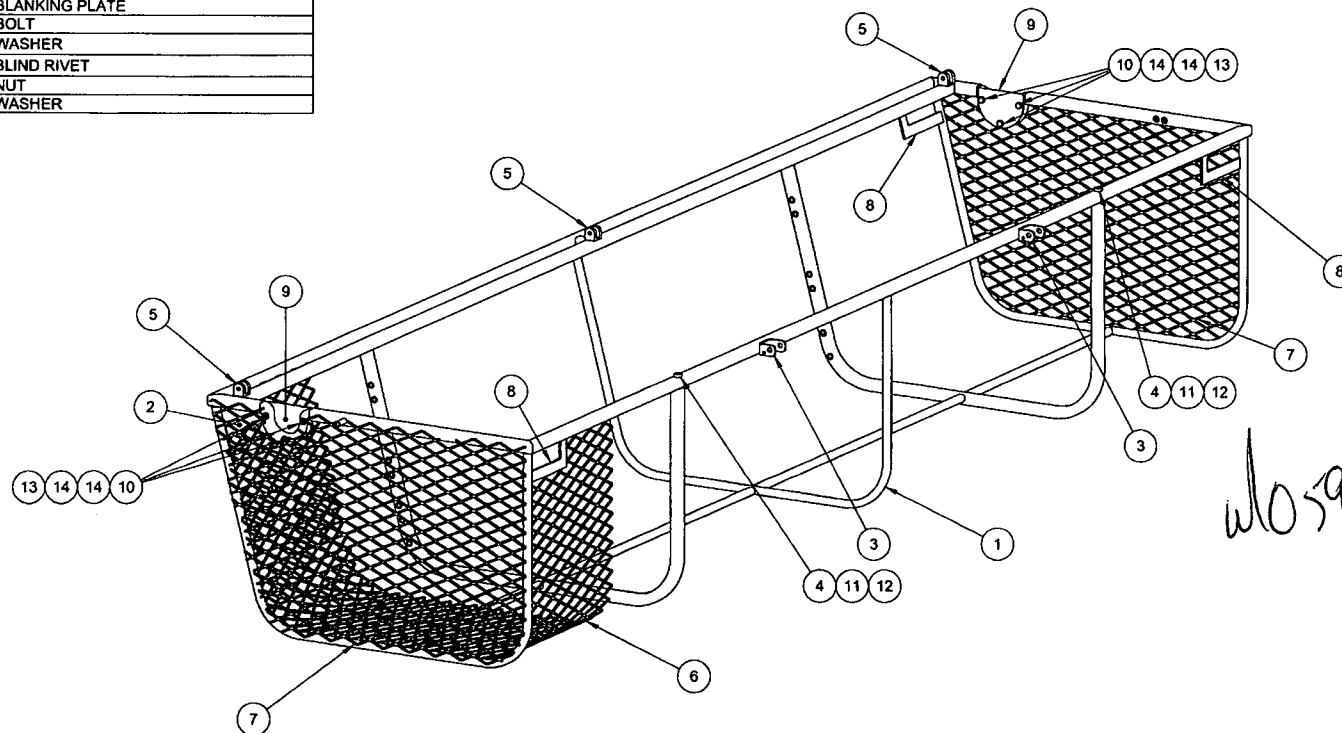
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

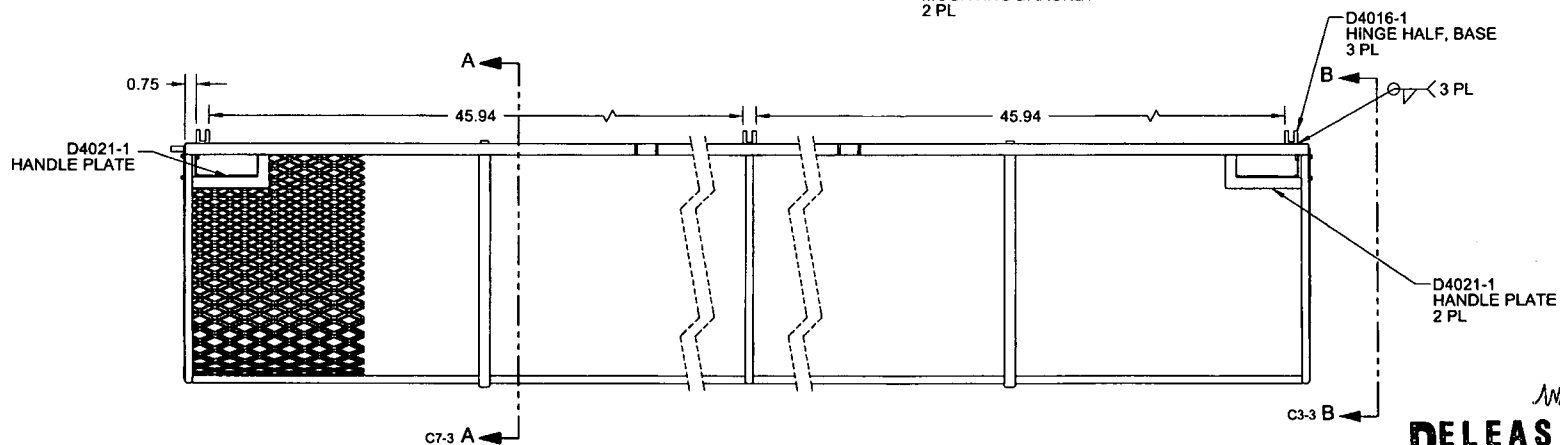
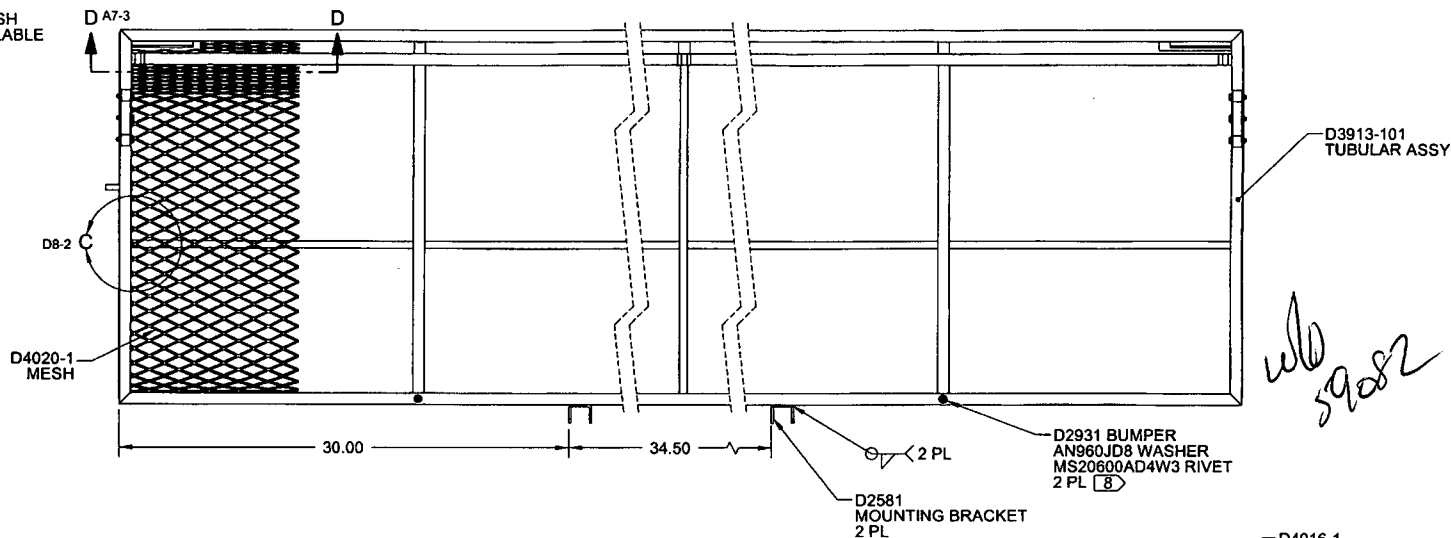
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

RELEASED
2010-03-22
JWP

A NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.16		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		DRAWING NO. D3913	REV. A
		TITLE LONG BASKET BASE ASSY (350)	SCALE NTS
COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

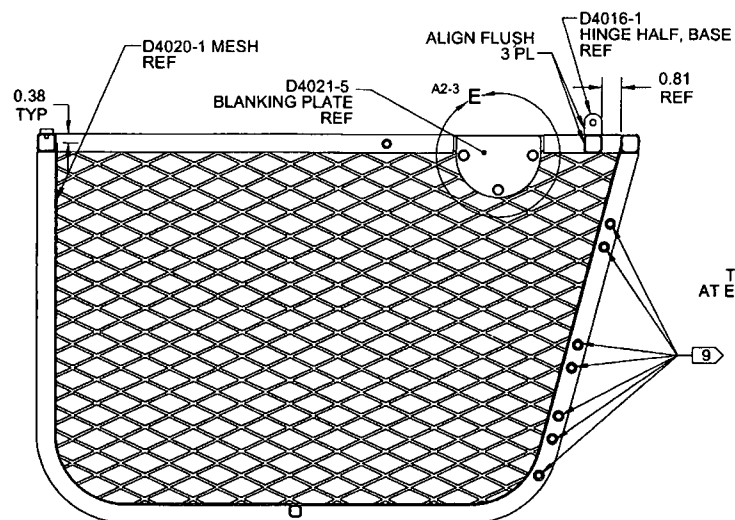
DETAIL C D7-2



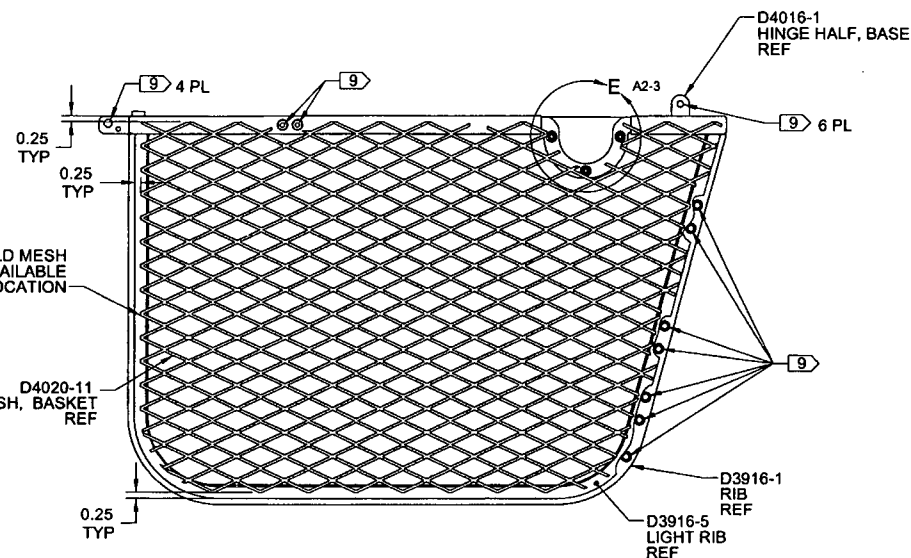
D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-03-27

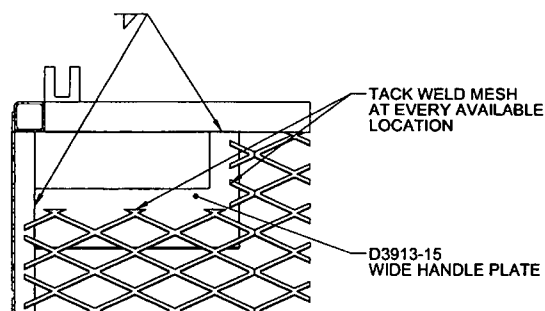
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



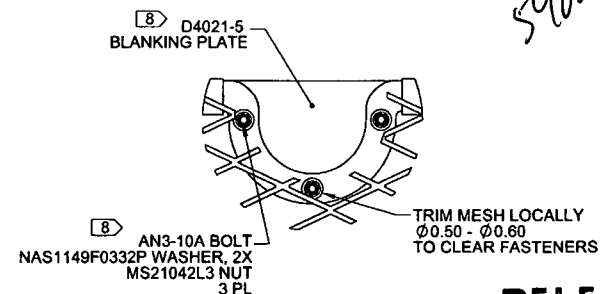
SECTION A-A A5-2



VIEW B-B A2-2



SECTION D-D D7-2
TYPICAL FOR ALL
HANDLE PLATES



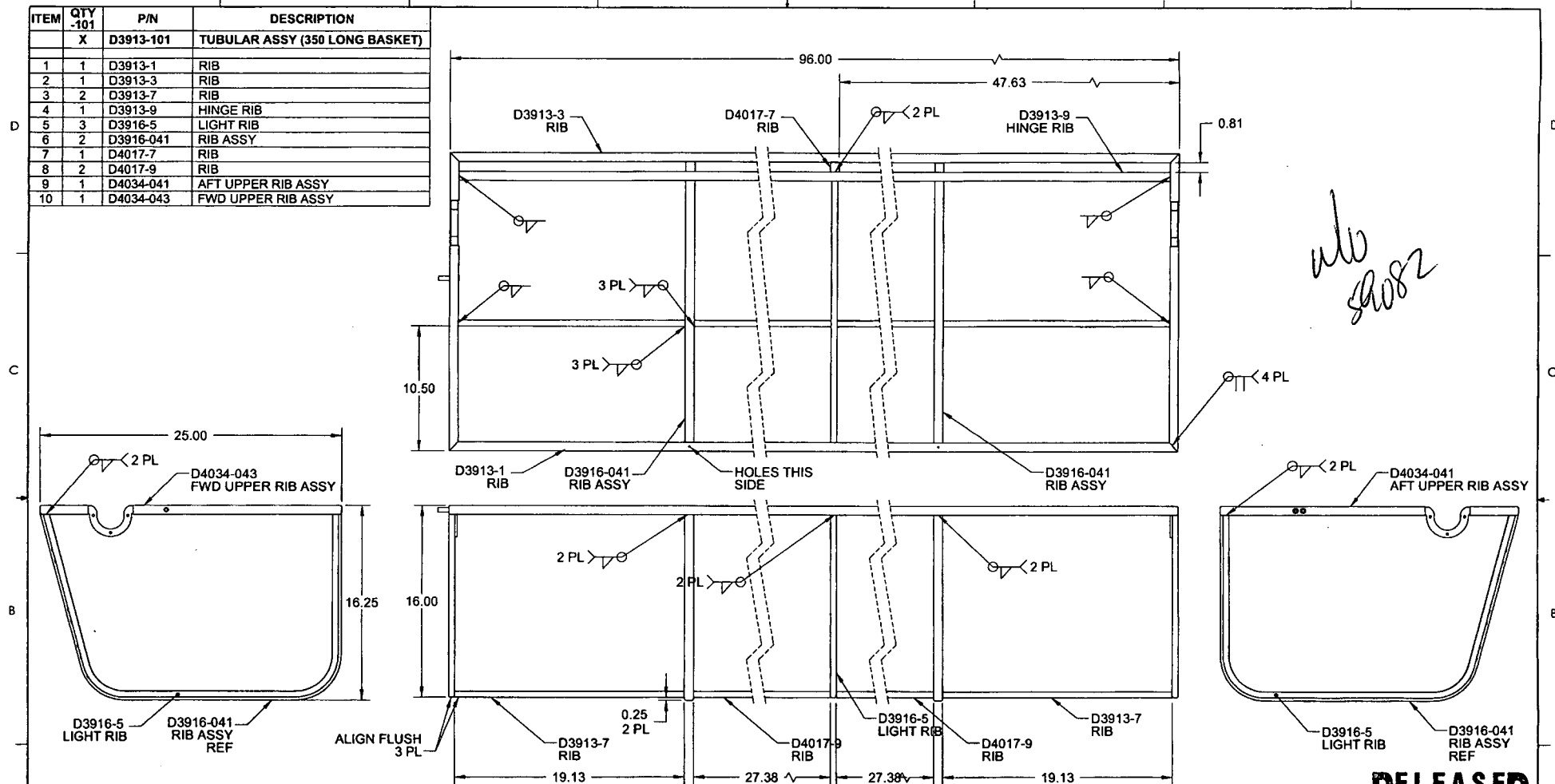
DETAIL E D2-3
D6-3

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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RELEASED
2010-03-22

WLB
59082

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



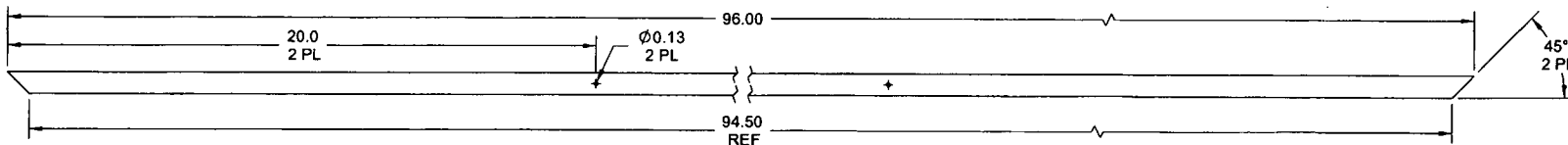
8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

NOTES:

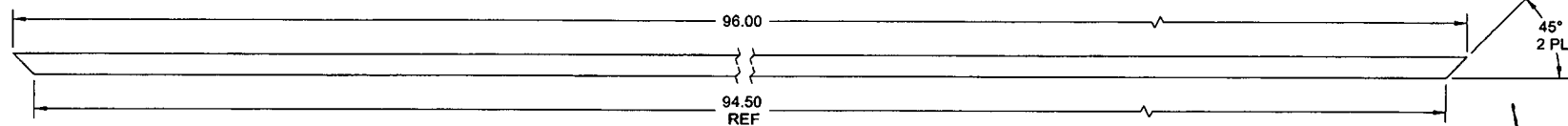
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3913-101
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	A	DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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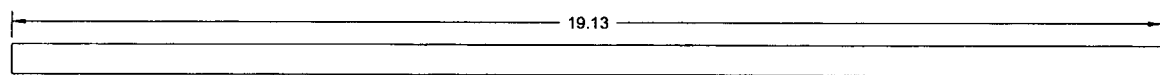
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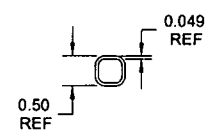
D3913-1 RIB



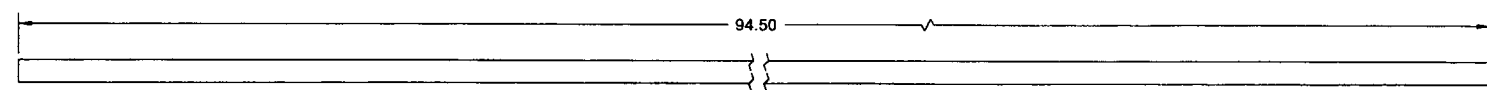
D3913-3 RIB



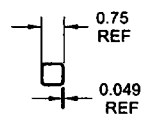
D3913-7 RIB



Handwritten: uld 59082



D3913-9 HINGE RIB

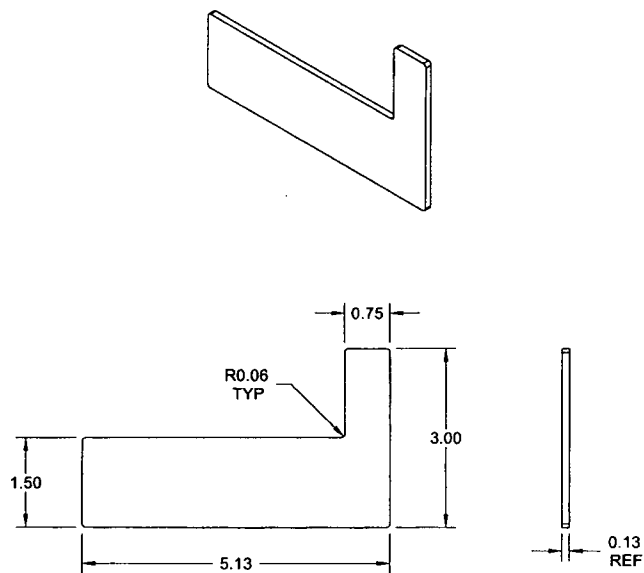


NOTES:

- 1) MATERIAL -1, -3, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

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MFG. APPR.		D3913	SHEET 5 OF 6
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DE APPR.		LONG BASKET BASE ASSY (350) NTS	
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D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JHH	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D3913	SHEET 6 OF 6
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